

Work Order ID 68314

Monday, April 11, 2011 1:37:11 PM



Page 1

Item ID: D3542-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 4/11/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-04-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3542	Rev A

100	BAND SAW	0.00							
	Bandsaw								
	Jeaspa Bandsaw								
	Memo	0.00							
	Cut blank 4.0" long								

11.05-10

10

110	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS 1								
	HAAS CNC vertical machine #1								
	Memo	0.00							
	1- Mill as per Folio FA684 Rev: <i>AA</i> & Dwg D3542 Rev: <i>A</i> <input type="checkbox"/> 2-Deburr per dwg D3443								

11.05-10

11.05-10

120	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
	Quality Control								
	Memo	0.00							

11.05-10

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Start Date: 4/11/2011 Start Qty: 10.00

Required Date: 4/15/2011 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

SL 11/05/11

10



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10 BR 11-5-12

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

10x Ø M-11/05/13

*****ENSURE TO MASK INSIDE BORE***** START TIME:

32201 OVEN TEMPERATURE: 1250 FINISH

TIME:

32201

2:20

1:20

M115128

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D3542-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 4/11/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11/5/13 SP (102)

170

Identify as per dwg & Stock Location: 245

0.00



Packaging

Memo

0.00

Packaging

11/5/13 (102) SP

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/16 SP

11-05-16 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

Monday, April 11, 2011 1:37:17 PM

Page 1

Work Order ID: 68314

Parent Item: D3542-1

Parent Item Name: Bracket



Start Date: 4/11/2011

Required Date: 4/15/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev: A New Issue 07-04-23 JLM
IPP Rev: B updated powder coat per NCR 07.05.16 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B30000X01.5 00		Purchased	No			100	f	15.5000	0.333333	3.333333			



6061-T6 Bar 3.00 x 1.50



Location

Loc Qty

Loc Code

MAT010

15.5

109058

5

114468

10.5

3.33 *4/11/11*

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

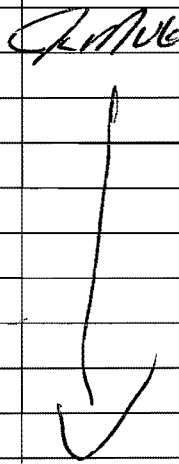
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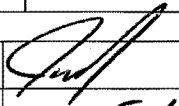
NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order:	68314
Description: Bracket		Part Number:	D3542-1
Inspection Dwg: D3542 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø2.010	+0.005/-0.000	2.0125	-			
Ø2.50	+0.012/-0.001	2.499	✓			
3.75	+/-0.030	3.749	✓			
2.50	+/-0.010	2.497	-			
1.00	+/-0.010	1.001	✓			
0.06 x 45°	+/-0.030 x 0.5°	.055	✓			
Ø0.266	+0.006/-0.001	0.268-270	✓			
1.00	+/-0.030	1.010	-			
0.50	+/-0.030	.506	✓			
0.500	+/-0.010	.501	✓			

Measured by: 	Audited by: SL	Prototype Approval:	N/A
Date: 11-05-10	Date: 11/05/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM 	

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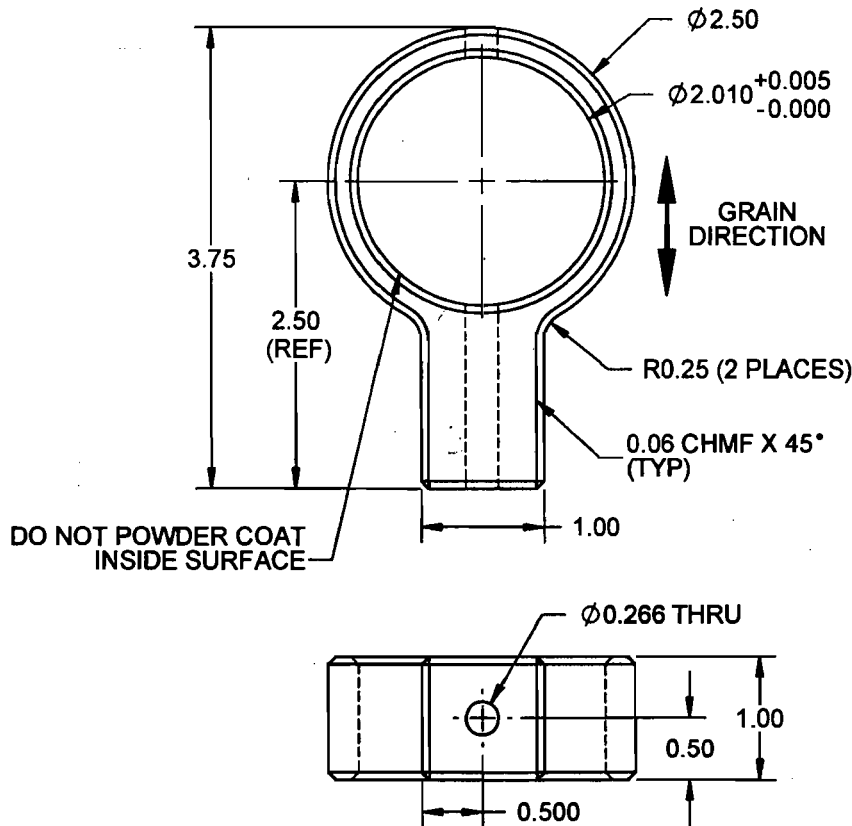
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DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3542	REV. A SHEET 1 OF 1
DATE 06.11.27	TITLE BRACKET		SCALE 2:3
REV A	DATE 06.11.27	DESCRIPTION NEW ISSUE	

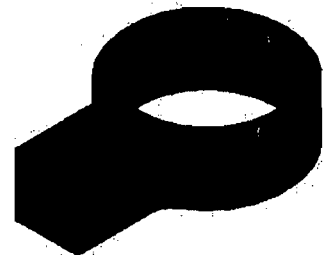
RELEASED
07.04.02



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *48314*

11-04-11

D3542-1 BRACKET



NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3 EXCEPT WHERE NOTED
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3542-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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